

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1 OR EARLIER,
REF. FAA STC SR02024SE

1.0 PURPOSE

The purpose of this DSI is to provide instructions for customers to modify the forward end of the D119-646-XXX skidtubes using the DSI 9594-011 Kit to make the skidtubes compatible with the Agusta ground handling wheels. One kit modifies 2 skidtubes. After CHG 001, portions of this modification may have been incorporated in production and therefore will not need to be incorporated in the field.

2.0 PROCEDURE

Modify the skidtubes as follows:

- 2.1 Rotate the D3407-041 Tow Ring to the vertical position as necessary.
- 2.2 Mark holes in the center ridge as shown in Figure 1. Drill through skidtube with Ø0.500" (12.7 mm drill), and countersunk to Ø0.650 x 100°, two places per side.
- 2.3 Remove and discard the hardware retaining the forward Cap. Countersink the existing holes to Ø0.385 x 100°.
- 2.4 Deburr holes. Touch up affected areas with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 2.5 Bond D2579 spacers into the Ø0.500 holes center in the skidtube using Magnobond 6398. Grind flush prior painting as shown in Figure 1.
- 2.6 Apply one coat of MIL-P-85582 or MIL-P-2337 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
- 2.7 Fasten the forward Cap using MS24694-C52 Screws. Seal threads with Proseal 890. Ensure that screw heads sit below skidtube surface
- 2.8 Repeat steps 2.1 to 2.7 for opposite skidtube.

3.0 PART LIST

| Qty -011 | PART NUMBER | DESCRIPTION |
|-------------|----------------|--------------------------------|
| X | DSI 9594-011 | FWD GROUND HANDLING SPACER KIT |
| 4 | D2579 | CROSS BOLT SPACER |
| 4 | MS24694-C52 | SCREW |

4.0 WEIGHT AND BALANCE

This modification has negligible effect on weight and balance.

| | | | |
|------------|--|---|--------------|
| B | ADD INSTRUCTION TO REMOVE EXISTING CAP MOUNTING HARDWARE AND REPLACE WITH COUNTERSUNK SCREWS | DB | 13.02.20 |
| A | NEW ISSUE | RF | 12.02.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE USA, INC. | |
| DRAWN | DB | KENT, WA | |
| CHECKED | MB | DRAWING NO. | REV. B |
| MFG. APPR. | N/A | DSI 9594 | SHEET 1 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FWD GROUND HANDLING SPACER KIT | NTS |
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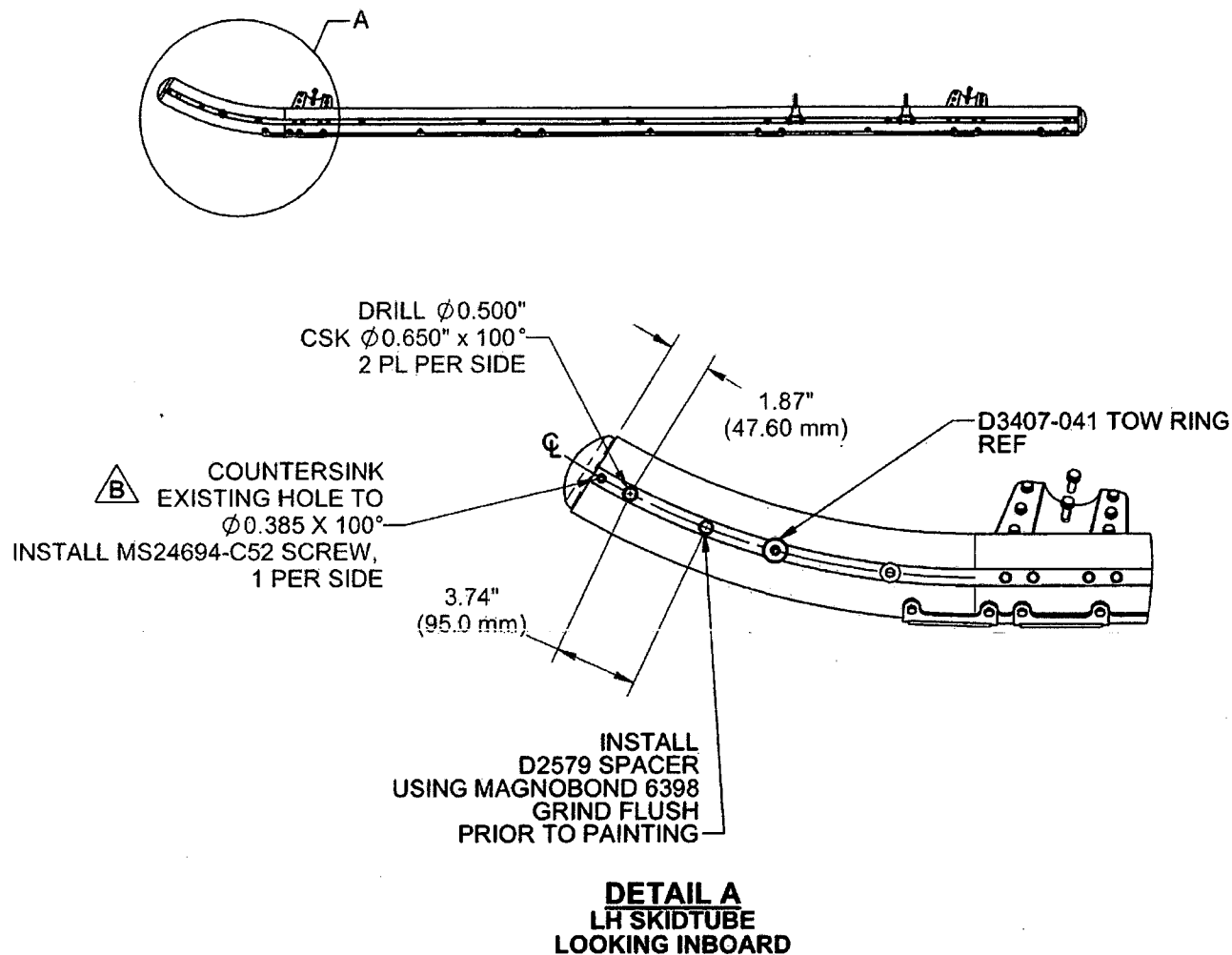


FIGURE 1. MODIFIED D119-646-XXX SKIDTUBE

| | | | |
|------------|--------------------|--|--------|
| DESIGN | RF | DART AEROSPACE USA, INC KENT, WA | |
| DRAWN | DB | | |
| CHECKED | MB | DRAWING NO. DSI 9594 | REV. B |
| MFG. APPR. | N/A | SHEET 2 OF 2 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FWD GROUND HANDLING SPACER KIT | NTS |
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